

# Work Order ID 60065

June 24, 2010 8:57:52 AM



Page 1

Item ID: D3200-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Post Block

Start Date: 6/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 6/30/10 Req'd Qty: 20.00



Customer:

Reference:

*10.06.25*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3200

Rev A

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank: 2.700" x 2.700

0.00

0.00

*LF 10/06/07*

20

*✓*

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3200-1 as per Folio FA337 and Dwg D3200U2-Deburr

0.00

0.00

*LF 10/06/28*

20

*✓*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*LF 10/06/28*

20

*✓*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

# Work Order ID 60065

June 24, 2010 8:57:52 AM

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Item ID: D3200-1

Accept

Revision ID:

Item Name: Door Post Block

Start Date: 6/24/10

Start Qty: 20.00

Required Date: 6/30/10

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 040

0.00

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*DT 10/06/28*

*20*

*10/06/28 (20)*

*10/06/30*

*MF 10-6-29*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 8:57:51 AM

Page 1

Work Order ID: 60065

Parent Item: D3200-1

Parent Item Name: Door Post Block



Start Date: 6/24/10

Required Date: 6/30/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	258.4000	0.05	1.052632			



UHMW 1" Black

Location

Loc Qty

Loc Code

MAT

258.4

113903

88

114624

170.4

1.0526

2.7 10/06/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>60065</i>
<b>Description:</b> Door Post Block		<b>Part Number:</b> D3200-1
<b>Inspection Dwg:</b> D3200	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

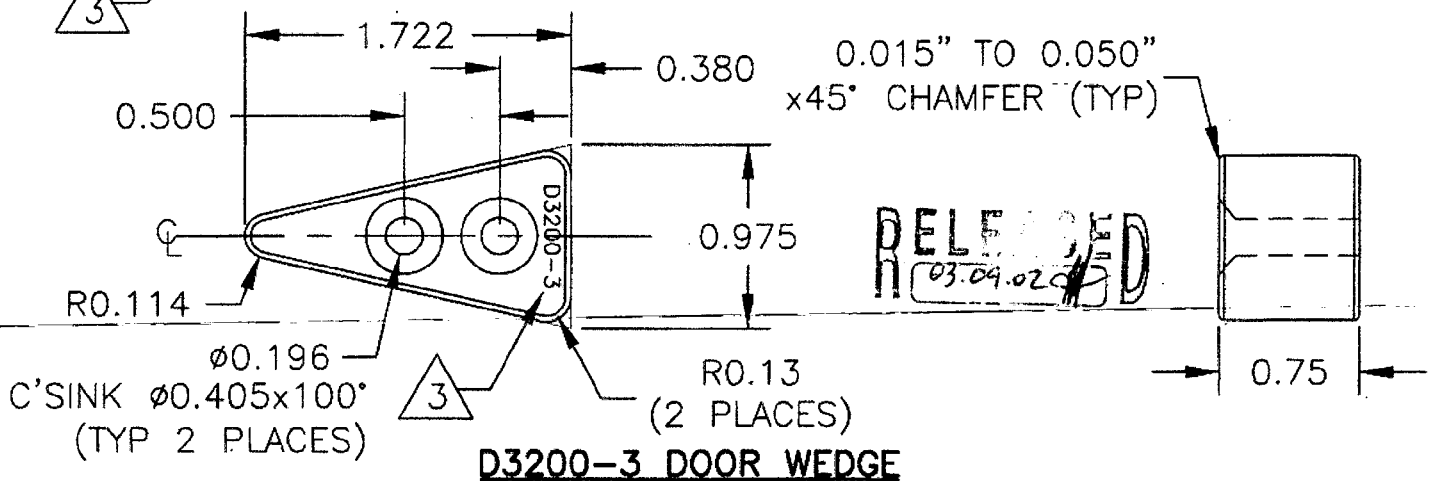
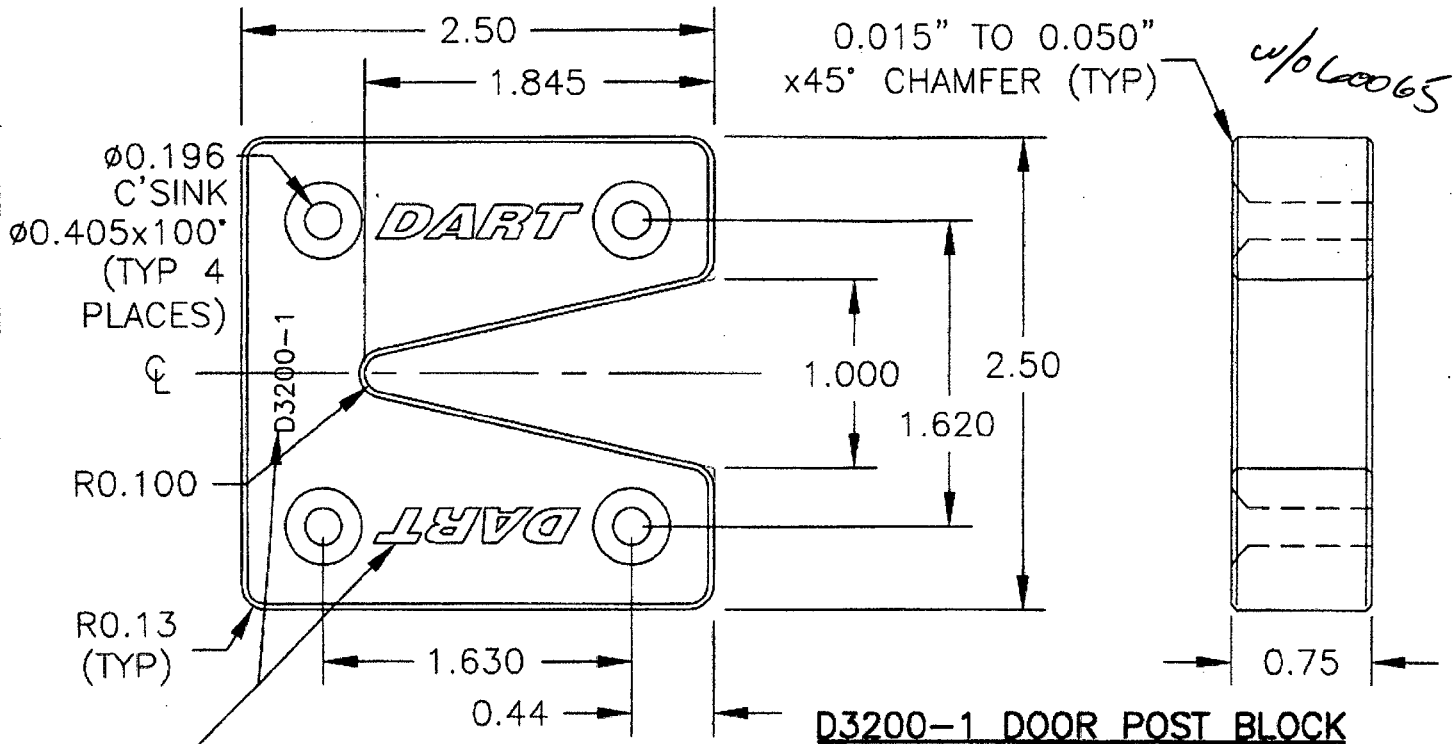
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005 -0.000	.197	✓			
0.405 x 100°	+/-0.010	.411	✓			
R0.100	+/-0.010	.100	✓			
R0.130	+/-0.010	.130	✓			
1.630	+/-0.005	1.630	✓			
0.440	+/-0.030	.432	✓			
2.500	+/-0.010	2.500	✓			
1.845	+/-0.010	1.843	✓			
0.015 – 0.050	N/A	.050	✓			
1.000	+/-0.010	1.000	✓			
1.620	+/-0.005	1.623	✓			
2.500	+/-0.030	2.499	✓			
0.750	+/-0.030	.744	✓			

<b>Measured by:</b> <i>SP</i>	<b>Audited by:</b> <i>DSI</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 10/06/28	<b>Date:</b> 10/06/28	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	<i>[Signature]</i>

**DART**

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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